

D4857-1 WIPER DEFLECTOR

UNDER REVIEW

14.4.30

RELEASED

2014 FEB 25
ECN 14-816

NOTES:

- 1 MATERIAL: KEVLAR #285/353 4H SATIN, EPOXY PREPREG, 250 °F CURE, 40% R/C
- 2 MATERIAL: CARBON FIBER PREPREG, ALDILA PREPREG SYSTEM 3K2X2-FR250-204/40 T300,
- 3 MATERIAL: ALDILA #120 E-GLASS AR250 WITH 48% RC;
- 4 FINISH: PRIMER IAW MIL-P-85582, 2-7 MIL MAX,
- 5 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6 UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 7 BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 8 IDENTIFICATION: BAG AND IDENTIFY WITH DART P/N D4857-1, AGUSTA P/N "TBD", REVISION AND BATCH NUMBER AS PER QSI 044 METHOD 6.7
- 9 WEIGHT: 0.35 lbs (.15 kg)
- 10 PART DIMENSIONS CONTROLLED BY CAD MODEL FILE D4857-1-c.IGES
- 11 SEE PAGE 2 FOR LAYUP SCHEDULE. MANUFACTURE IAW MPP 145. CURE 250 °F FOR 4 HOURS.

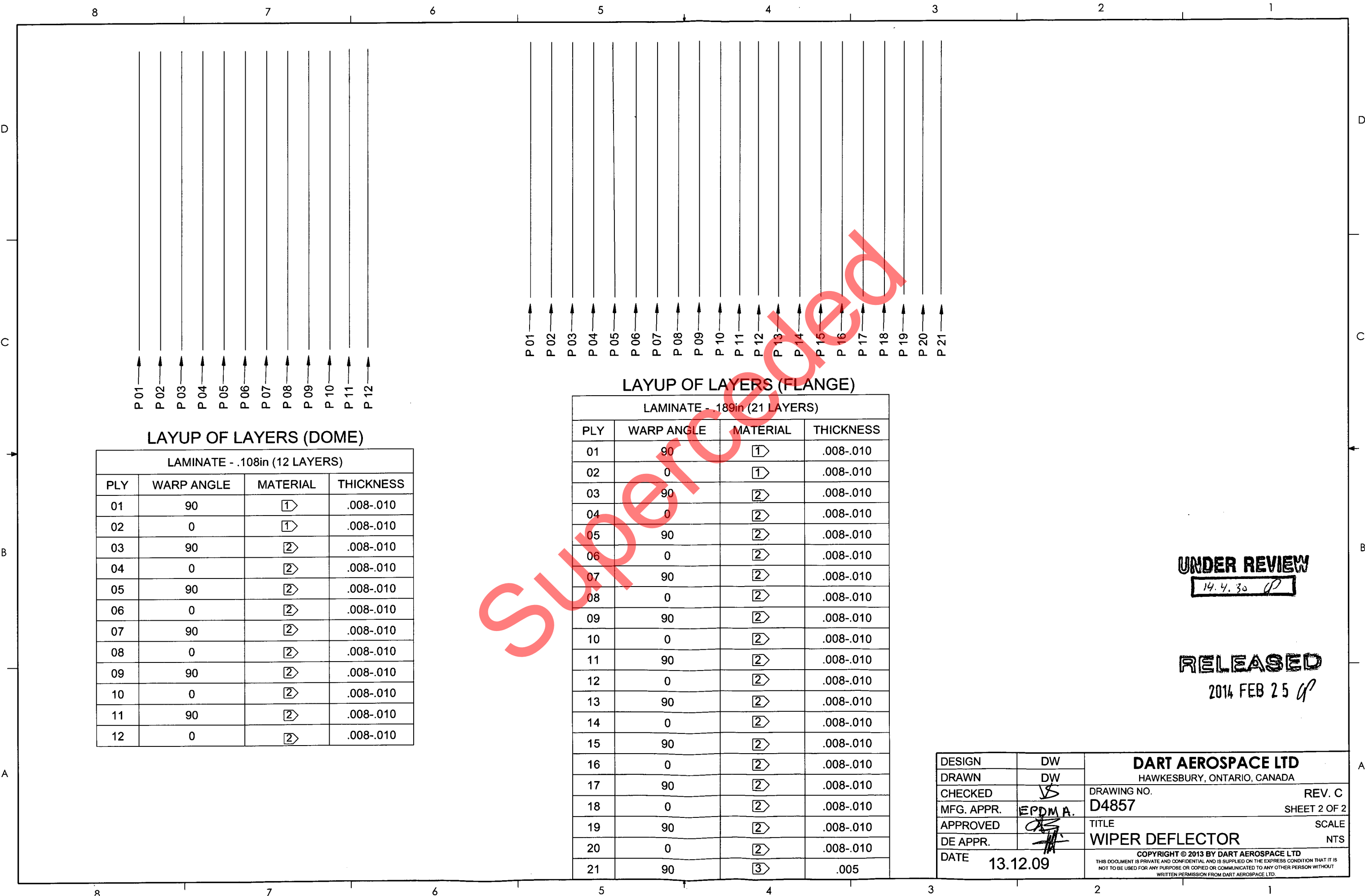
APPROVED

C	ADDED 4 MOUNTING HOLES	DW	13.12.09
B	REVISED BOM, DRAWING VIEWS, NOTES	PB	13.08.13
A	NEW RELEASE	DB	13.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	EPDMA	D4857	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WIPER DEFLECTOR	NTS
DATE	13.12.09	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Superceded

WELSH REVENUE

1999-2000



LAYUP OF LAYERS (DOME)

LAMINATE - .108in (12 LAYERS)			
PLY	WARP ANGLE	MATERIAL	THICKNESS
01	90	1	.008-.010
02	0	1	.008-.010
03	90	2	.008-.010
04	0	2	.008-.010
05	90	2	.008-.010
06	0	2	.008-.010
07	90	2	.008-.010
08	0	2	.008-.010
09	90	2	.008-.010
10	0	2	.008-.010
11	90	2	.008-.010
12	0	2	.008-.010

LAYUP OF LAYERS (FLANGE)

LAMINATE - .189in (21 LAYERS)			
PLY	WARP ANGLE	MATERIAL	THICKNESS
01	90	1	.008-.010
02	0	1	.008-.010
03	90	2	.008-.010
04	0	2	.008-.010
05	90	2	.008-.010
06	0	2	.008-.010
07	90	2	.008-.010
08	0	2	.008-.010
09	90	2	.008-.010
10	0	2	.008-.010
11	90	2	.008-.010
12	0	2	.008-.010
13	90	2	.008-.010
14	0	2	.008-.010
15	90	2	.008-.010
16	0	2	.008-.010
17	90	2	.008-.010
18	0	2	.008-.010
19	90	2	.008-.010
20	0	2	.008-.010
21	90	3	.005

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DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	VS	DRAWING NO. D4857	REV. C
MFG. APPR.	EPDM A.		SHEET 2 OF 2
APPROVED	AS	TITLE WIPER DEFLECTOR	SCALE
DE APPR.	TH		NTS
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Superseded

MADE IN USA

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